

20

FIG. 5A

FIG. 5B

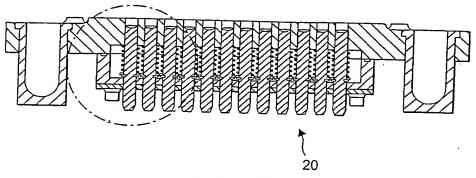


FIG. 6A

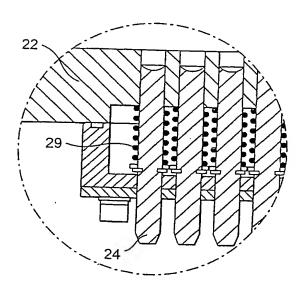
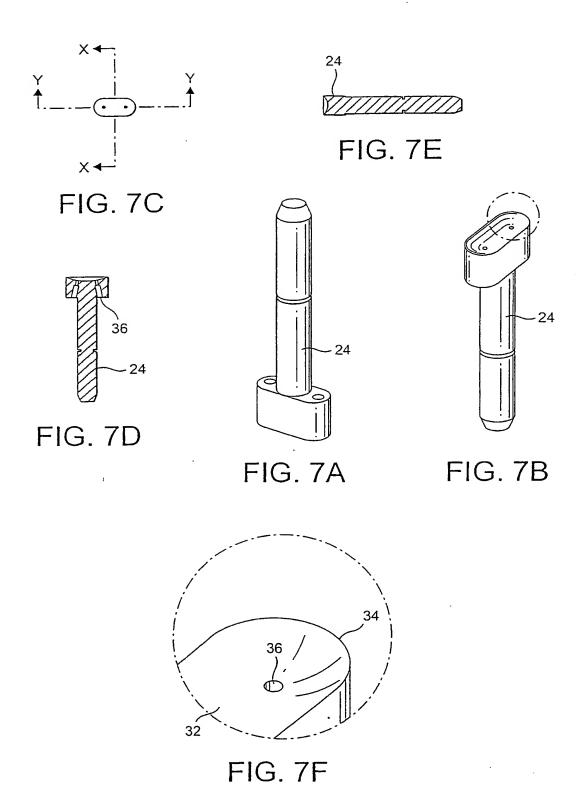
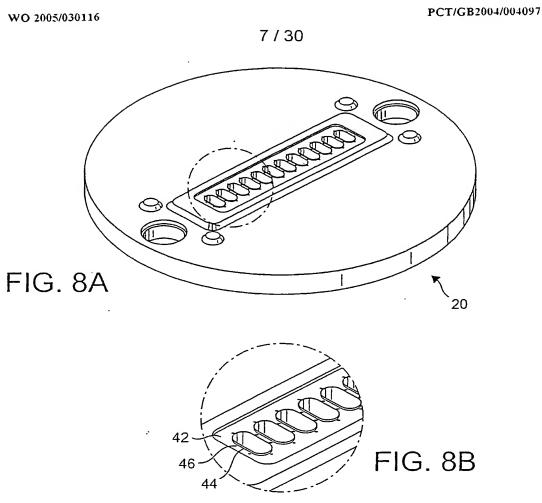


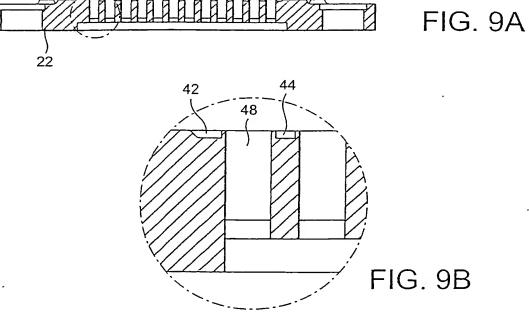
FIG. 6B



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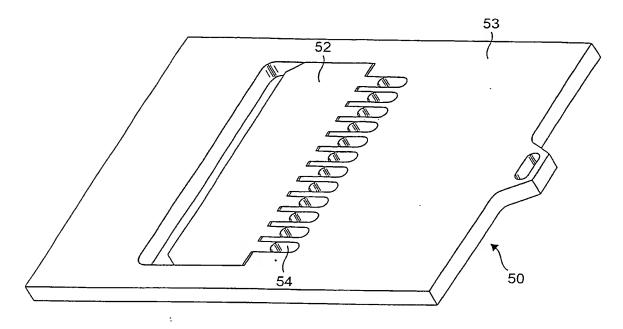


FIG. 10

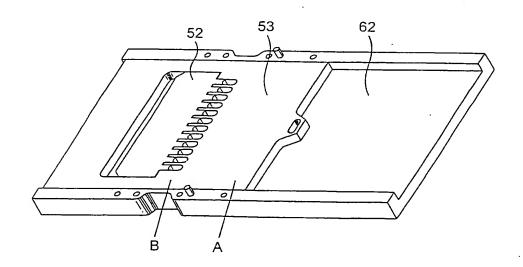
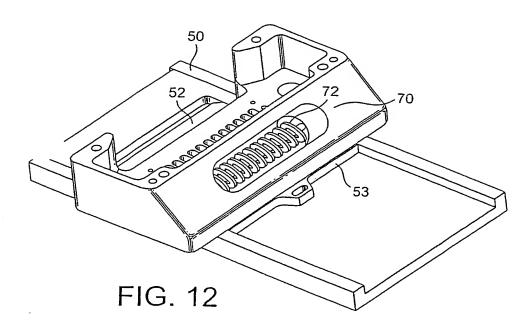
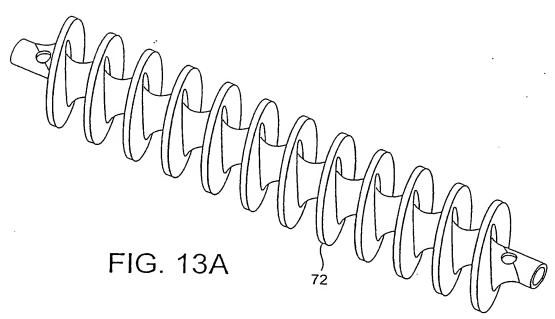
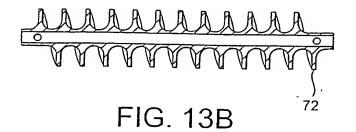
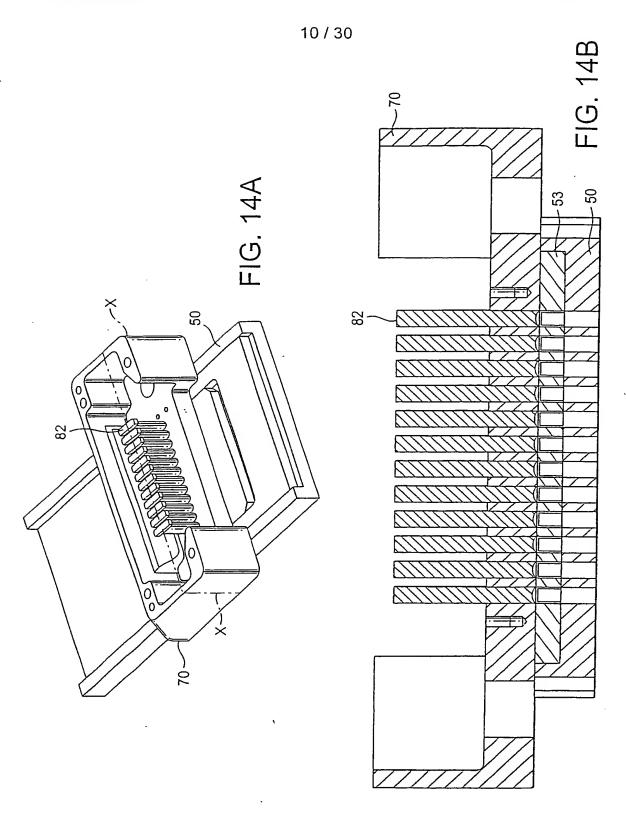


FIG. 11









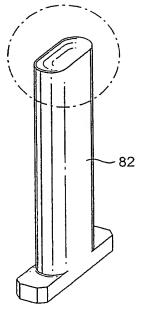


FIG. 15A

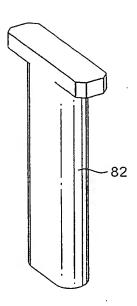
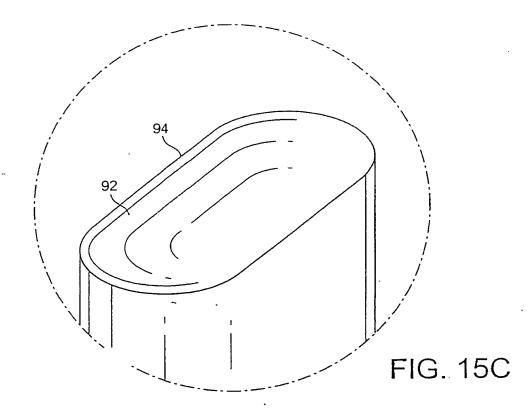


FIG. 15B



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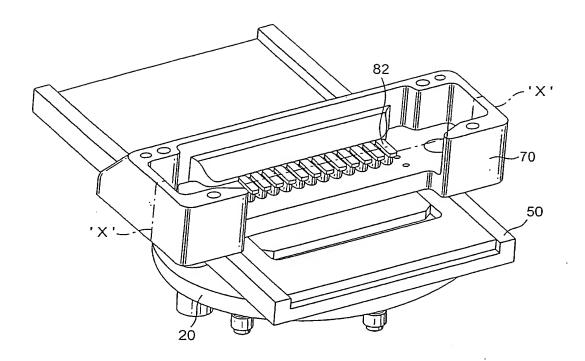
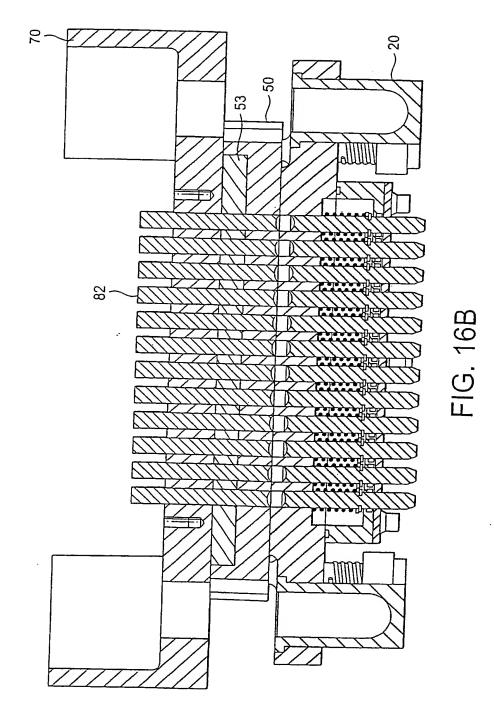


FIG. 16A



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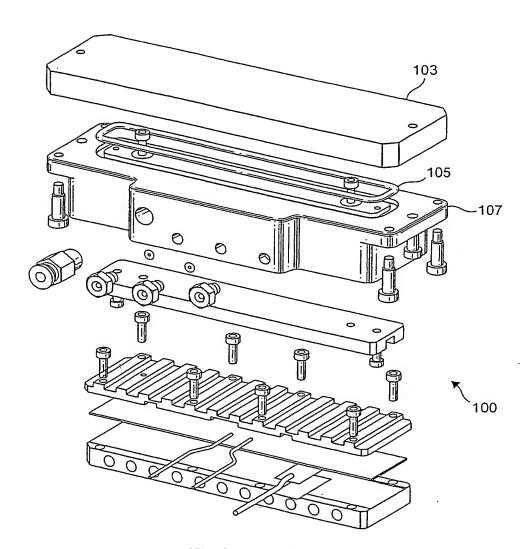


FIG. 17A

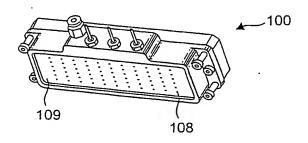


FIG. 17B

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9.5 9.0 8.5 8.0 7.5 7.0 6.5 6.0 Time (seconds) 5.5 5.0 4.5 4.0 3.5 2.5 2.0 7. 0.5 Position Pos 3 Pos 1 Index Pos 1 Pos 1 Pos 1 Pos 1 Pos 1 Rotate table through 90° Vent top vacuum on and Move thermoforming Close thermoforming Top vacuum on and Open thermoforming Move thermoforming Index film across Index film across hold lower vacuum operating position Lower vacuum on chamber 1 into Sub-process chamber 1 into parked position position 3 position 1 chamber 1 heat film chamber 1 Process A1 81 Σ 5 02 3 7 90 07 Index Film 2 Index Film 1 Description Index table Thermoform Film 1 to tablet shell form the half of the bottom

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FIG. 18 cont'd Pos 3 Move lower piston to 2nd Vent top vacuum on and thermoforming position Ready to index table Move thermoforming Close thermoforming Open thermoforming chamber 2 Top vacuum on and Engage cutting sytem operating position Lower vacuum on Ready to Index table hold lower vacuum Remove waste film chamber 2 into Disengage cutting chamber 2 heat film system ij Ξ 뚠 2 7 H 5 25 ೮ 7 Thermoform film 2 over from around the tablet the filled remove the waste film Cut and shell

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FIG. 18 cont'd

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Collect the

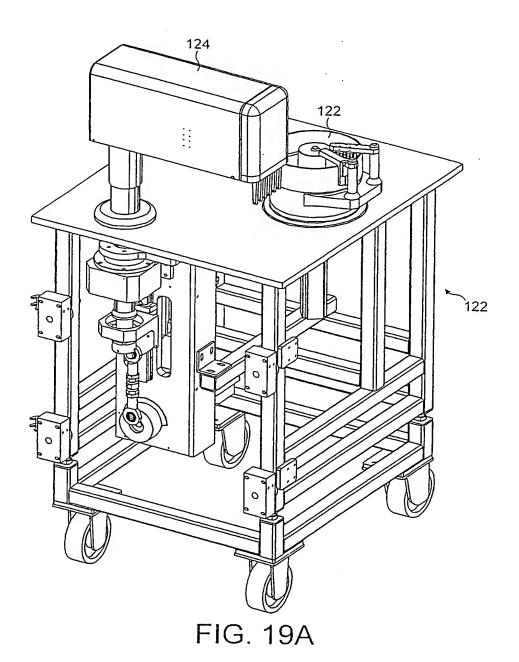
finished

tablets

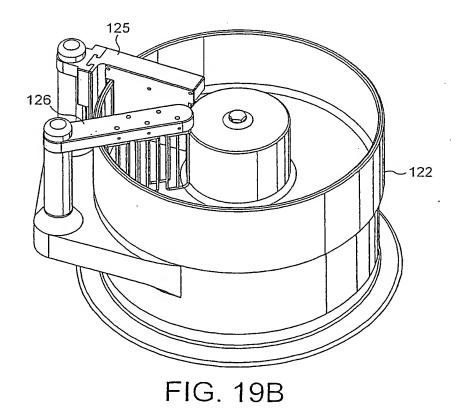
film edges together

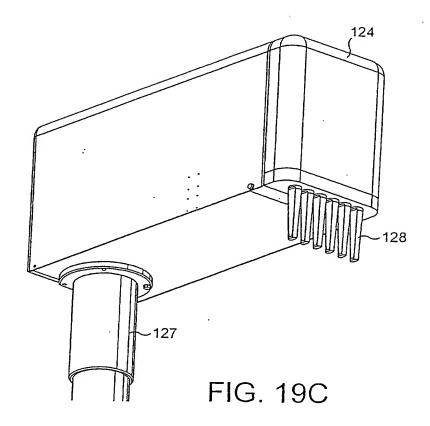
overlapped

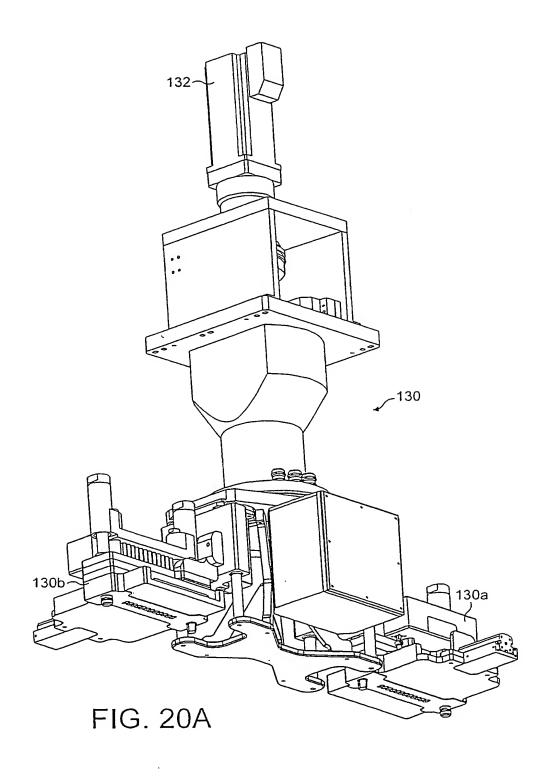
Seal the



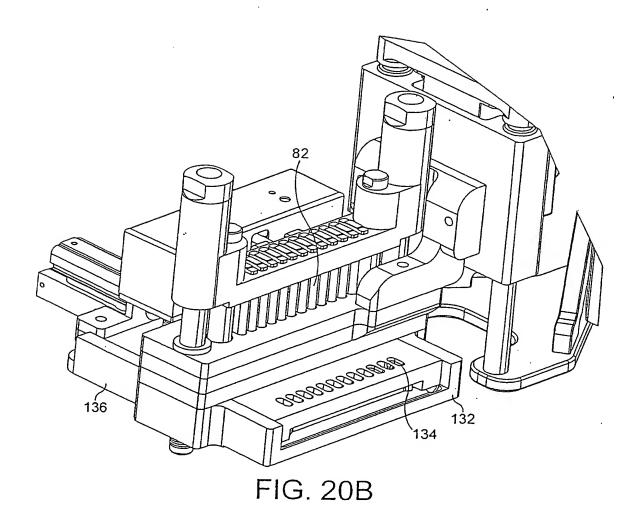
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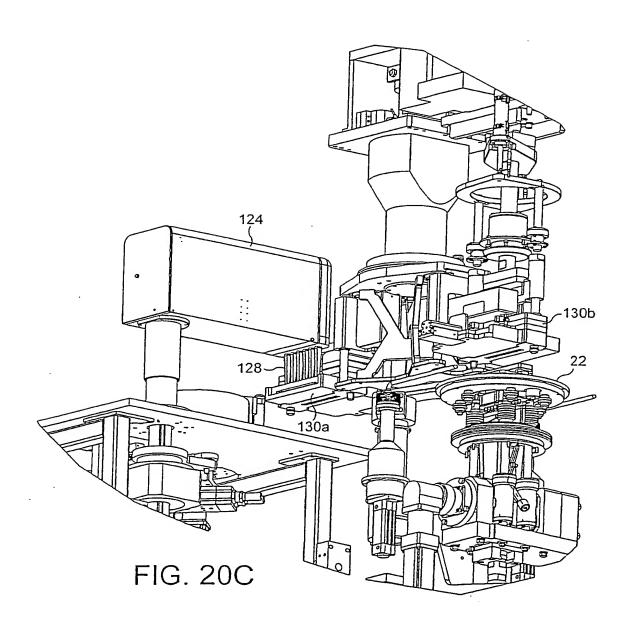


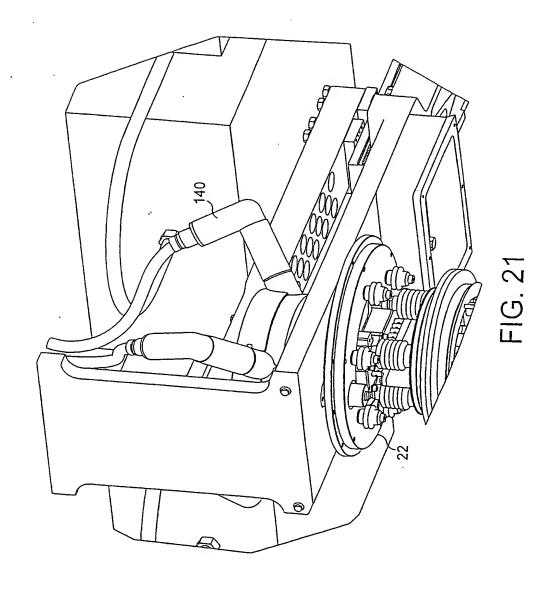




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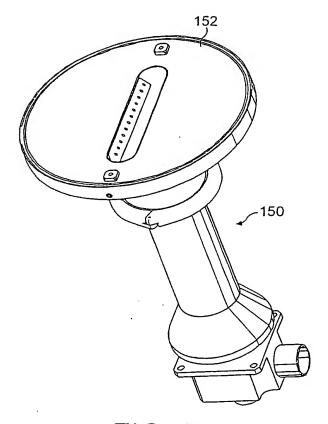
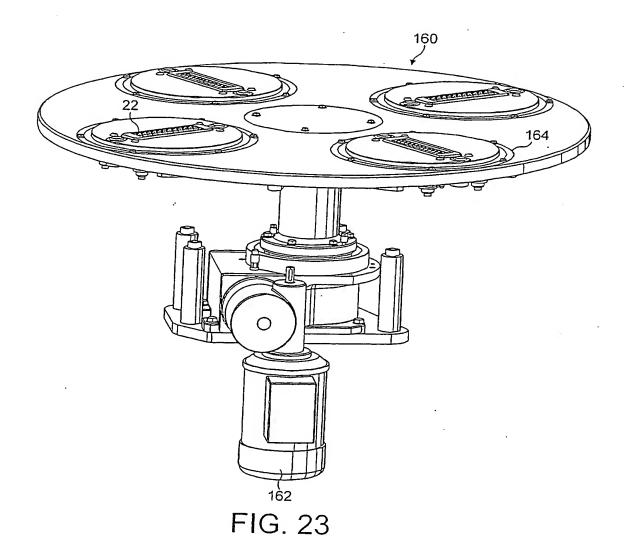
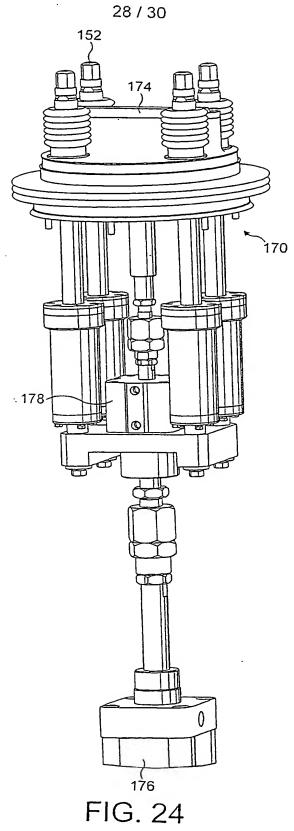
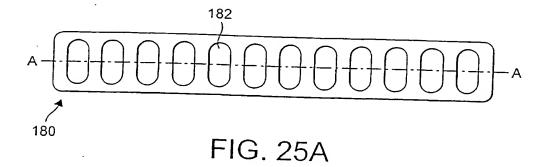


FIG. 22









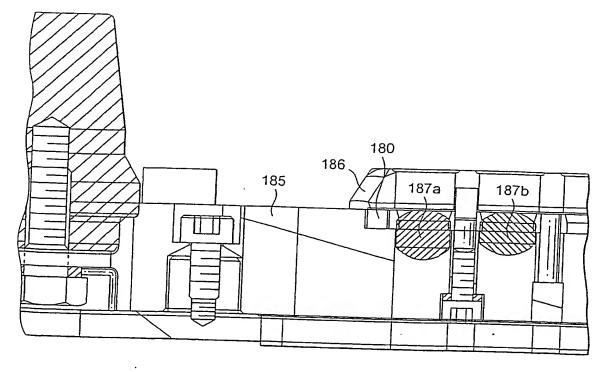


FIG. 25C

